

SUPRAMANGAN

TOP FEATURES

- When building up several layers, it is recommended that a buffer layer is deposited with 307 type MMA electrode.
- Flat welding position only.
- Shall be used in AC or DC+ current

CLASSIFICATION

EN 14700 ~E Fe9

CURRENT TYPE

AC, DC+

WELDING POSITIONS

Flat/Horizontal

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Cr	Ni	Fe
0.60	15	4.50	4.80	Rem.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Hardness (HB)
Typical values	AW	180

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 450	110-135
4.0 x 450	140-175

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 450	CBOX	135	6.5	W000258522
4.0 x 450	CBOX	95	6.5	W000258523

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.